

Work Order ID 61202

Wednesday, August 11, 2010 10:08:55 AM

Page 1

Item ID: D3065-5

Accept

Revision ID:

Item Name: Step Leg

Setup Start

Stop

Start Date: 8/11/2010 Start Qty: 60.00

Required Date: 8/25/2010 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mk*

Date: 10-8-11

Tooling:

Date:

Run Start




Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D necessary								
6061 .080	<input type="checkbox"/> Dwg Rev: <u>B</u>								
	<input type="checkbox"/> Prog Rev: <u>B</u>								
	<input type="checkbox"/> 2-Deburr if								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							
Quality Control									

IB 10-8-25

(58)

IB 10-8-25

S 10/08/30

counted
(x58)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

57- BL 10-9-1

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/09/01

57

150

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

E/S 10/09/01 (57)

W/O:		WORK ORDER CHANGES					
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Start Date: 8/11/2010 Start Qty: 60.00

Required Date: 8/25/2010 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/09/02

MF
10-9-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Parent Item: D3065-5



Parent Item Name: Step Leg

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: ☐ C ☐ 02.11.01 ☐ Incorporated D3066-1 IPP ☐ KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080		Purchased	No			100	sf	48.3512	1.0798	68.19789			
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1810-8-25

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT21

48.3512

113438

0.3512

115389

48

115389



Dart Aerospace Ltd

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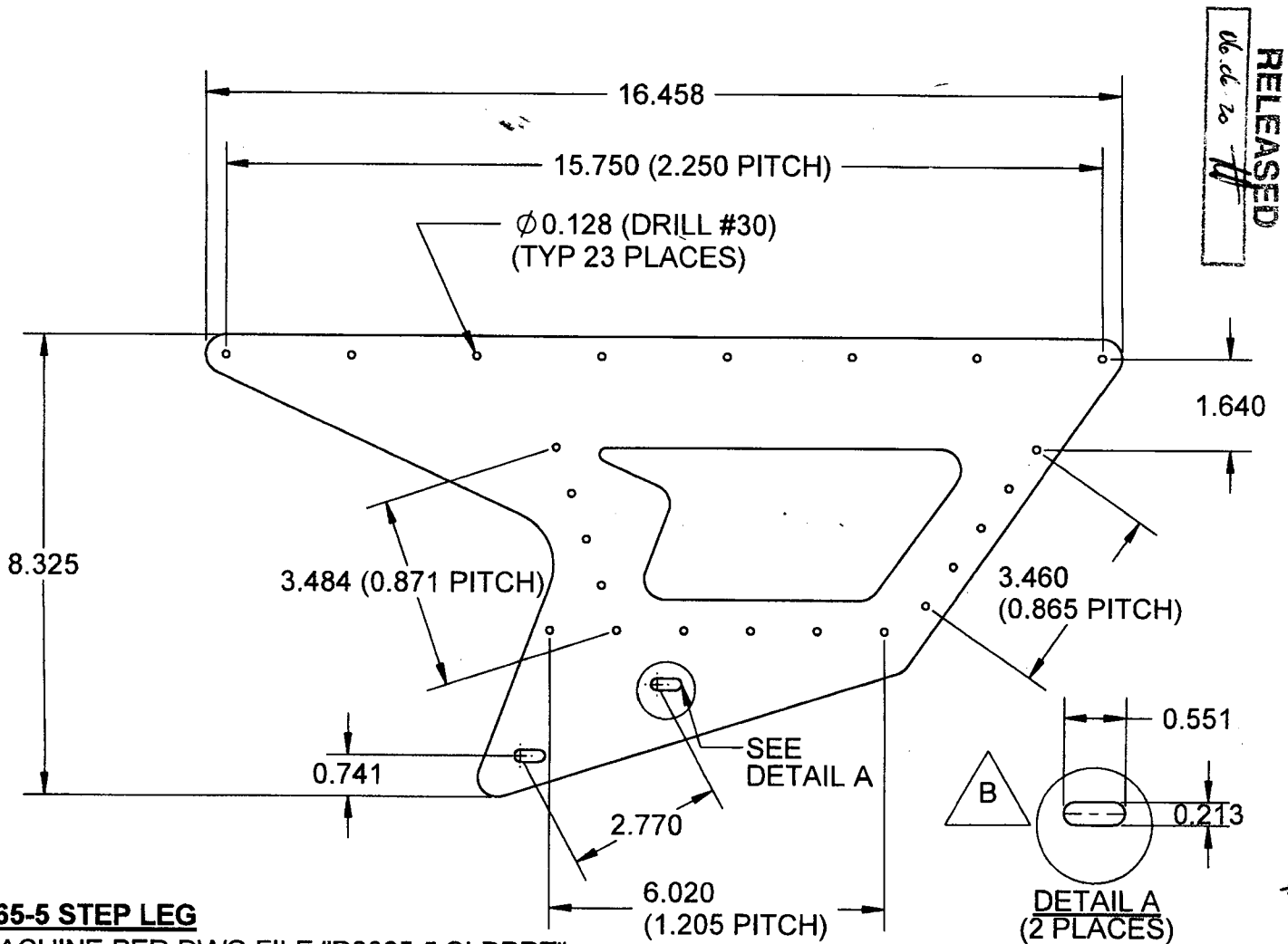
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
PH	PH	DRAWING NO. D3065
DATE	06.05.23	TITLE STEP LEG ASSEMBLY
		REV. B
		SHEET 4 OF 5
		SCALE 1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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